

Work Order ID 58481-2

Friday, May 07, 2010 11:32:48 AM

split to qty 1
1005-07



Page 1

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ring

Start Date: 5/7/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 5/12/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

YMF

Date: 10-5-7 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3413

Rev A

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

10-5-7

①

110



QC

Quality Control

QC2- set parts off machine FAI/FAIB

0.00

Memo

0.00

10-5-7

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sidlosloz

④

Work Order ID 58481

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Page 2

Item ID: D3413-1

Revision ID:

Item Name: Ring

Start Date: 5/7/2010 Start Qty: 5.00

Required Date: 5/12/2010 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: 1:55pm OVEN TEMPERATURE:

1:45pm FINISH TIME: 4:00°

0.00

0.00

1005-07

8 106107

100507

Work Order ID 58481

Friday, May 07, 2010 11:32:48 AM

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Item ID: D3413-1

Accept

Revision ID:

Item Name: Ring

Start Date: 5/7/2010 Start Qty: 5.00

Required Date: 5/12/2010 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

0.00

8/20/10/2

EC

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: 51420 0.00

0.00

MF 10-5-7

Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release 0.00

0.00

MF 10-5-7

QC

Memo

Quality Control

Picklist Print

Page 1

Friday, May 07, 2010 11:32:48 AM

Work Order ID: 58481



Parent Item: D3413-1

Parent Item Name: Ring

Start Date: 5/7/2010

Required Date: 5/12/2010

Comments: IPP Rev:A: 05.09.13 'New issue' KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	15.0000	0.25			



304 BAR .250 x 4.00



1310-5-7

Location

Loc Qty

Loc Code

MAT53

15

113084

15

113084

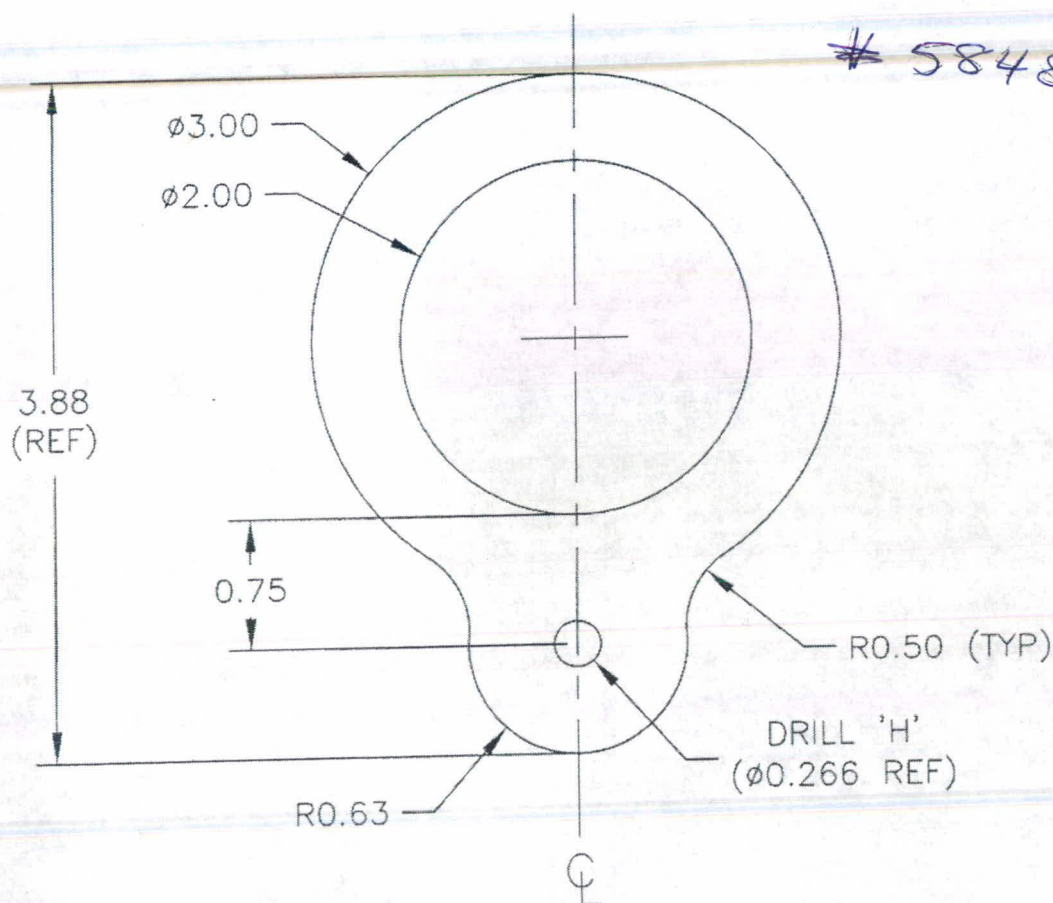
①



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 H

58481



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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